

RUSH. ship tues 7

Work Order ID 70375



Page 1

Monday, June 06, 2011 9:02:40 AM

Item ID: D3874-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 6/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/06/06 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3874	Rev A
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100		0.00
-----	--	------



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x3

DL
11/06/07

105		0.00
-----	--	------



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 270° F

Time IN: 4:30 PM 11/06/06

Time OUT: 7:00 AM 11/06/07

DL
11/06/07



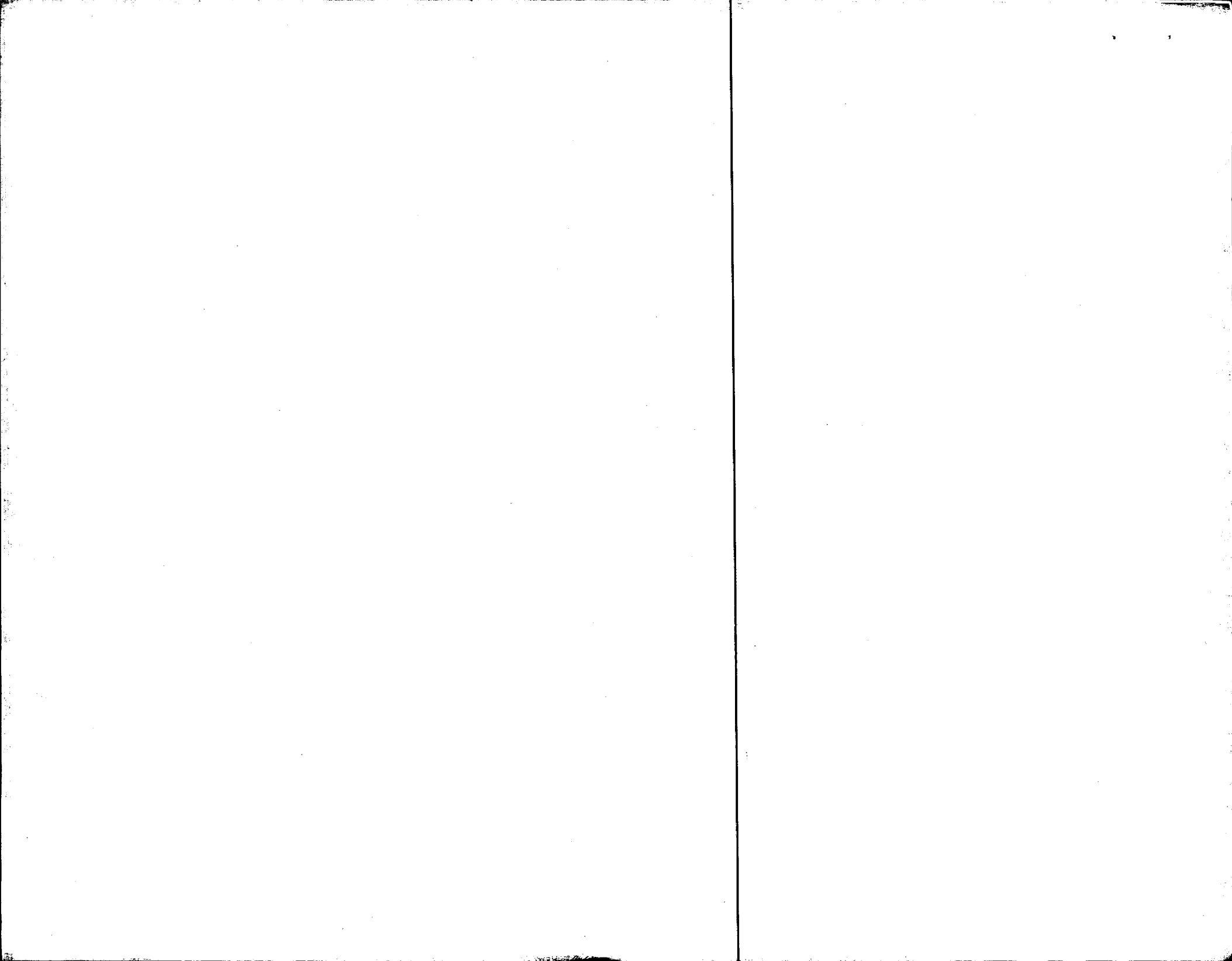
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 70375

Monday, June 06, 2011 9:02:40 AM



Page 2

Item ID: D3874-1

Accept



Setup Start



Revision ID:

Item Name: Floor Protector

Stop



Start Date: 6/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

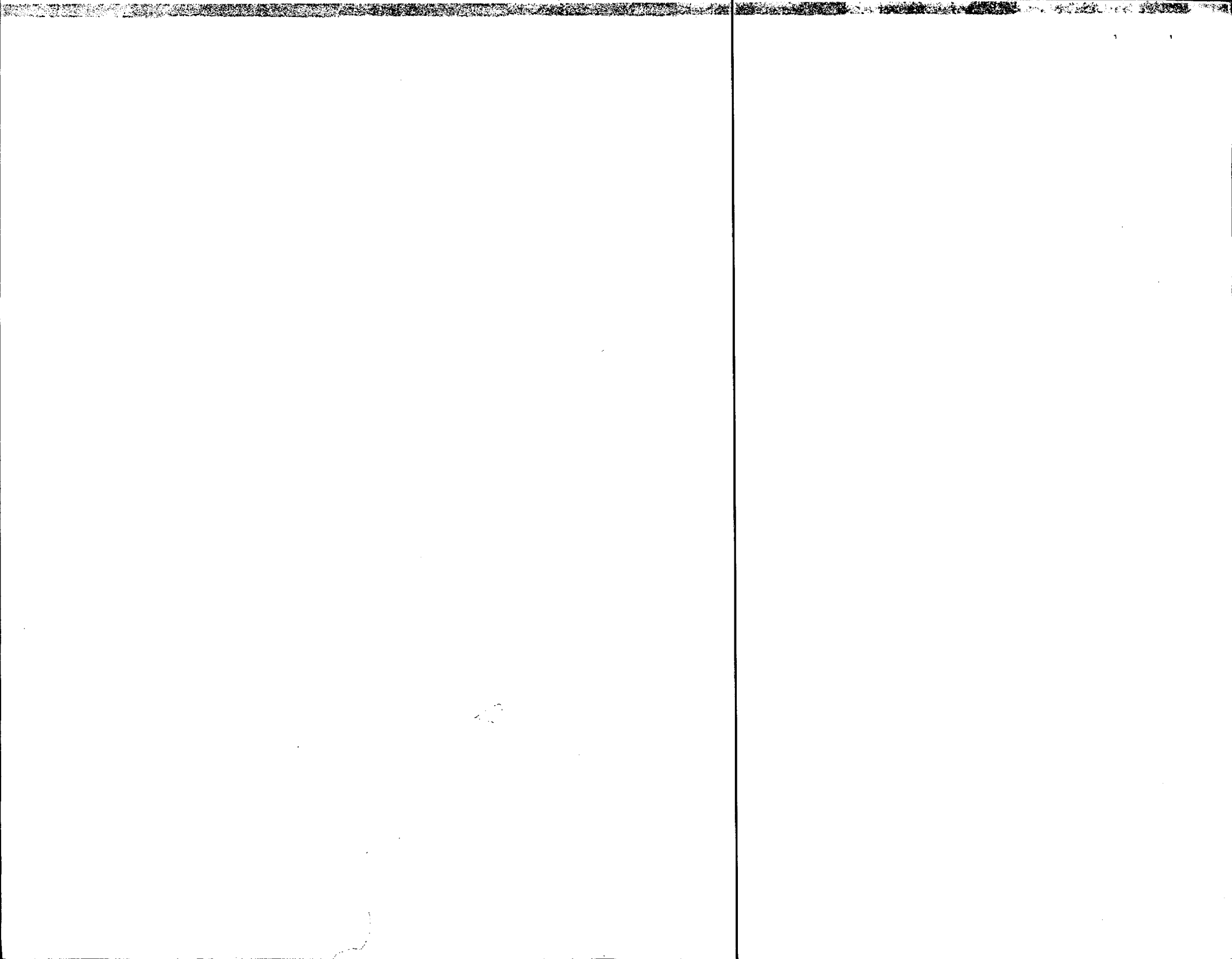
Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 Thermoform Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA038 using tool DT9474 Dwg Rev: <u>A</u> Folio Rev: <u>B</u>	0.00 0.00				<u>x3</u>			<u>Dh</u> <u>11/06/07</u>
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect part for proper formation and texture	0.00 0.00				<u>x3</u>			<u>Dh</u> <u>11/06/07</u>
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<u>Suloclor</u>		<u>(x3)</u>			



[illegible]

Page 3

Accept

[illegible]**Setup Start**

Stop

[illegible]**Cust Item ID:**

Customer:

Reference:

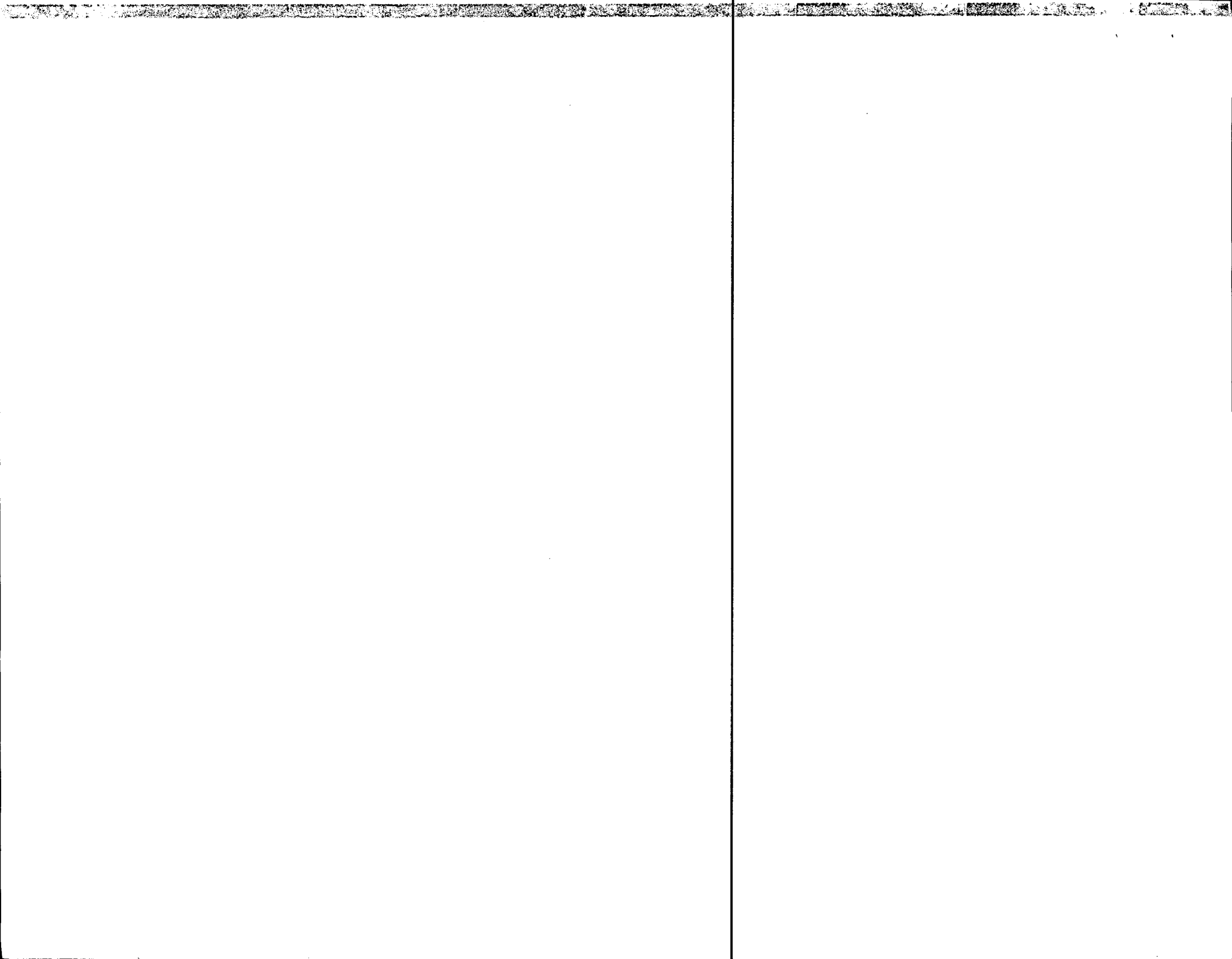
Run Start

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

Stop

Abstract

[illegible]



Work Order ID 70375

Monday, June 06, 2011 9:02:40 AM



Page 4

Item ID: D3874-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 6/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 191

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

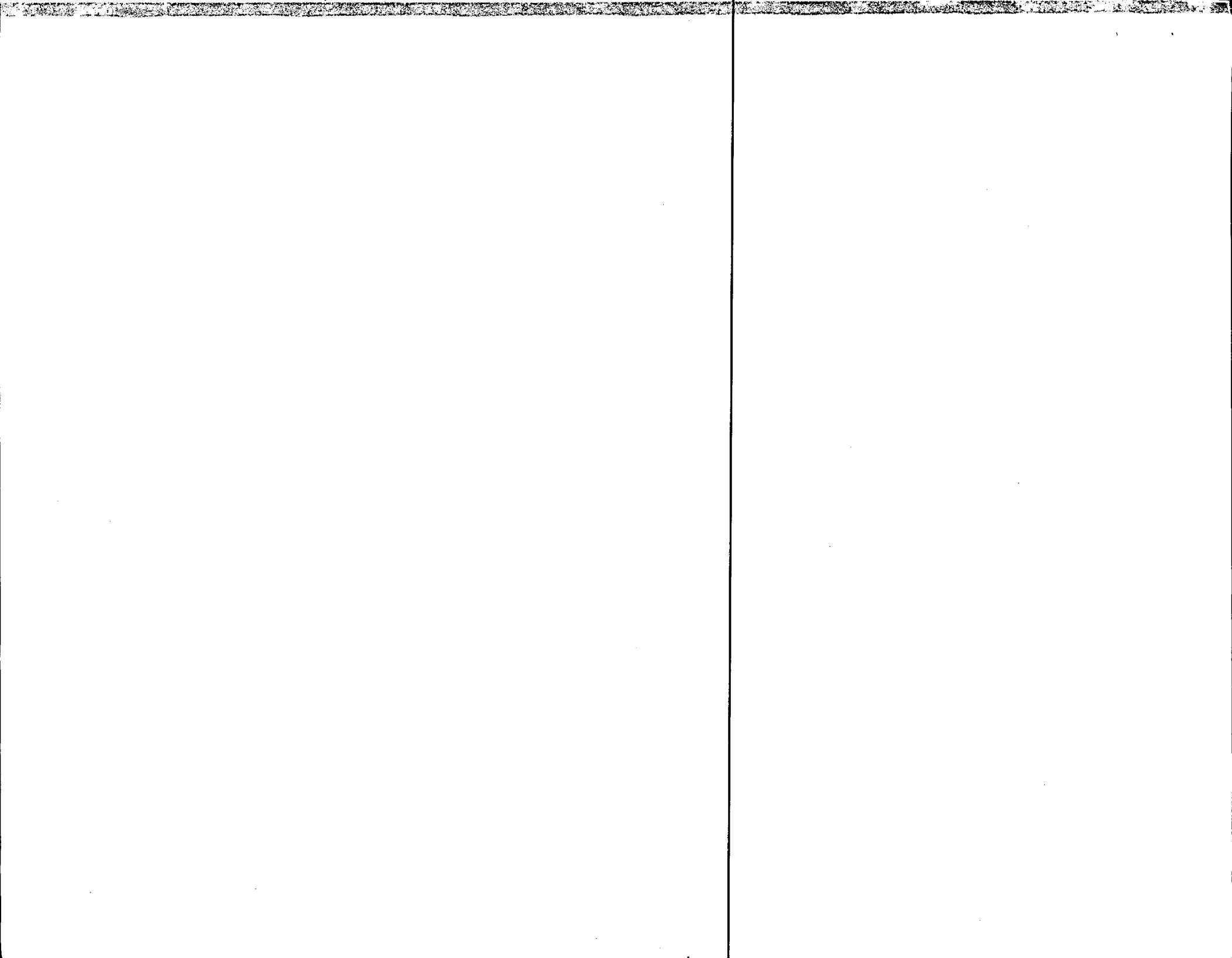
Memo

0.00

Quality Control

Handwritten signature and date: 11/6/78

Handwritten signature and date: 11/6/88
CL11/06/08



Picklist Print

Monday, June 06, 2011 9:02:38 AM

Page 1

Work Order ID: 70375



Parent Item: D3874-1



Parent Item Name: Floor Protector

Start Date: 6/6/2011

Required Date: 6/7/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.118-90318-08

Purchased

No

100

sf

2,100.005

4.38

8.76



Lexan Sheet

Location

therm

Loc Qty

2100.00578

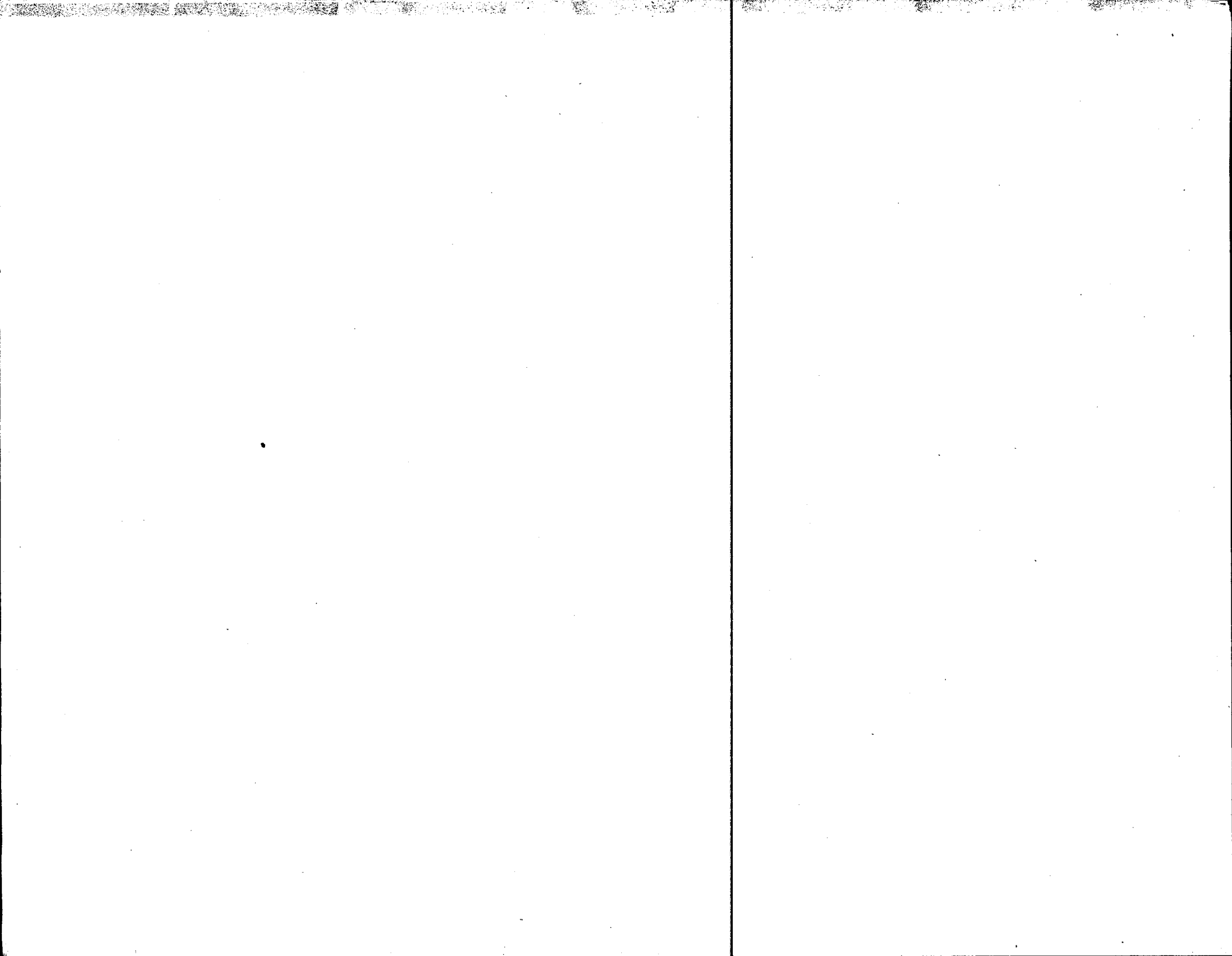
Loc Code

2100.00578

113127

13.14 sq ft.

DL
11/06/07



DART AEROSPACE LTD		Work Order:	70375
Description: Floor Protector		Part Number:	D3874-1
Inspection Dwg: D3874 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	<u>De.</u>	Date:	<u>11/06/07</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.053	✓		Visual DL-02	
0.065	Min	0.101	✓		Cal TH-DT	
0.5	Min	0.527	✓		Visual DL-02	

Measured by:	<u>De.</u>	Date:	<u>11/06/07</u>
Audited by:	<u>S</u>	Date:	<u>11/06/07</u>
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ <u>JS</u>	<u>MA</u>

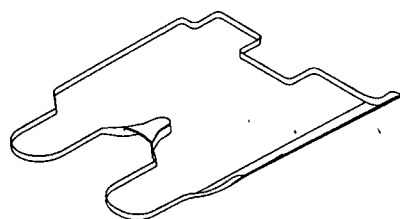
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

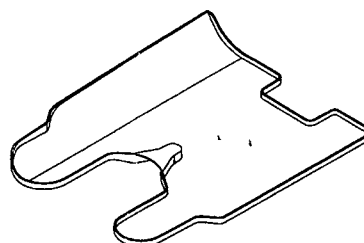
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

CL11106106
W10: 70375

RELEASED
[Signature]

A	NEW ISSUE		PH	09.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3874 TITLE FLOOR PROTECTOR SCALE NTS	REV. A	
DRAWN	<i>PH</i>		SHEET 1 OF 3	
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>			
DATE	09.01.29		<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

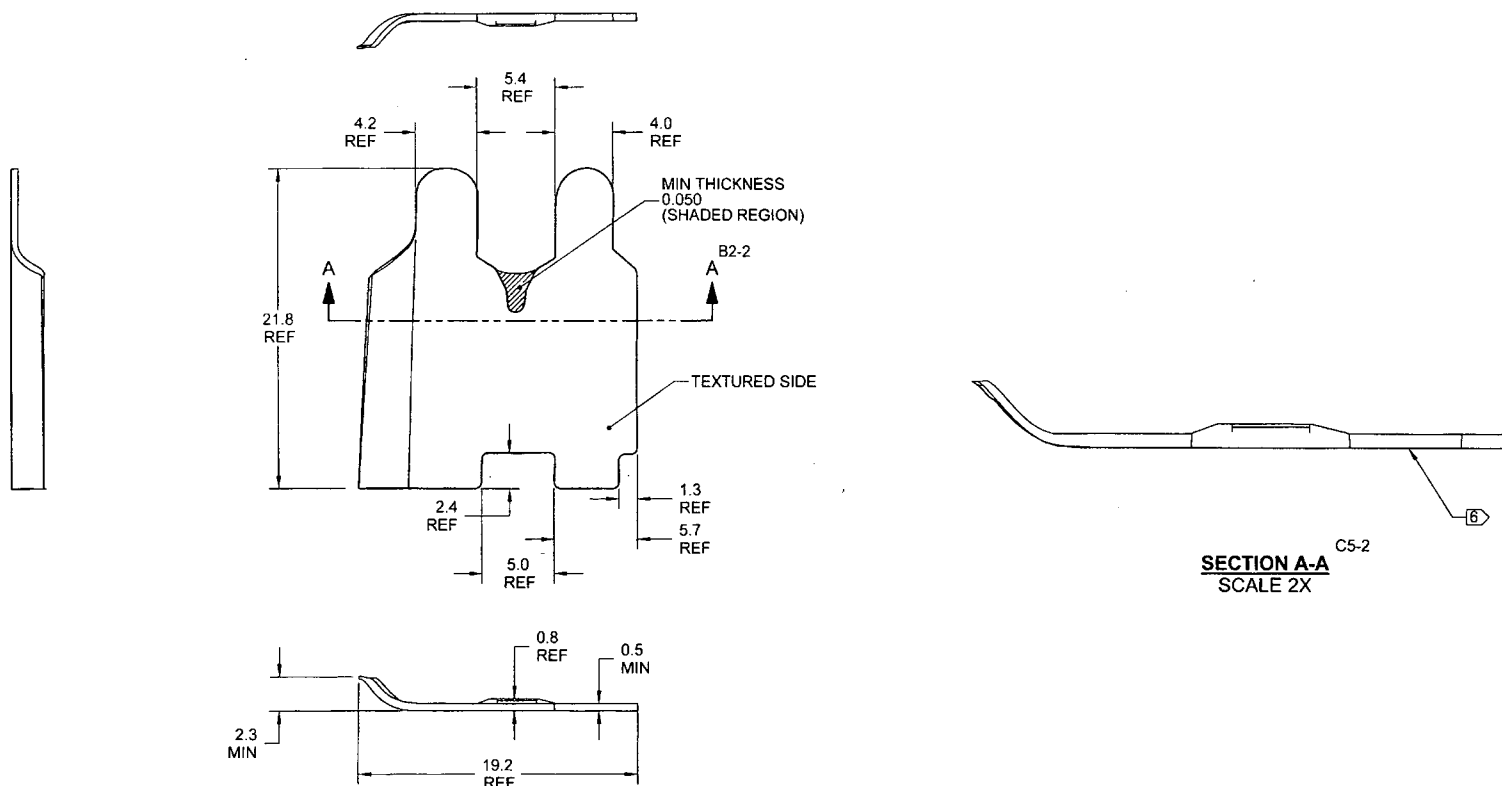
D

C

C

B

B



SECTION A-A
SCALE 2X

D3874-1 FLOOR PROTECTOR

RELEASED
9/25/05

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	09.01.29	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

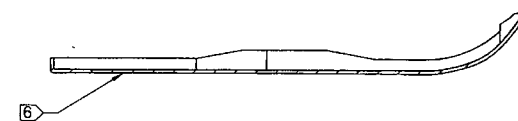
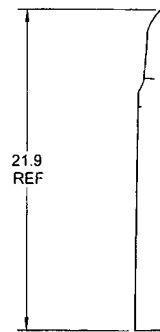
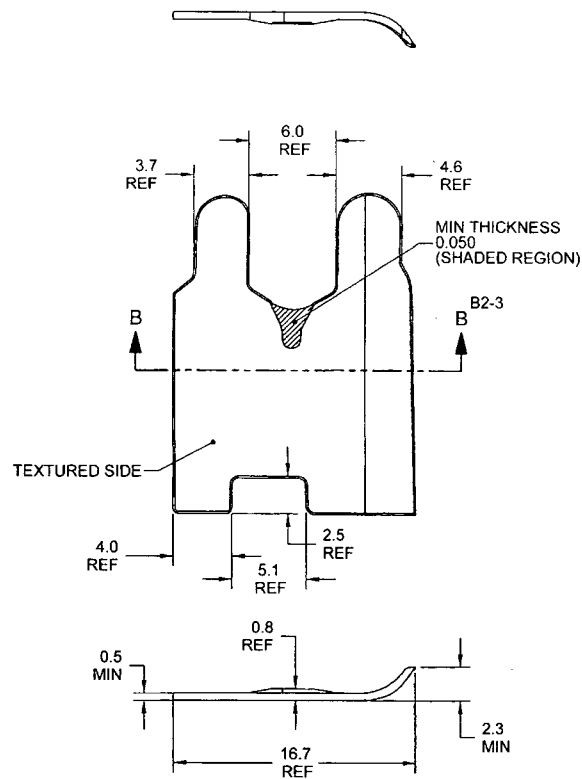
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

RELEASED
9/15/03

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

DESIGN	Per	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	Per			
CHECKED			DRAWING NO. D3874	REV. A
MFG. APPR.				SHEET 3 OF 3
APPROVED			TITLE	SCALE
DE APPR.			FLOOR PROTECTOR	NTS
DATE	09.01.29		<p>COPYRIGHT © 2009 BY DART AEROSPACE LTD</p> <p>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</p>	

